A_{Date:}

Thursday, 2/22/2007 2:57:37 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number

: 30813A

Estimate Number

: 10352

P.O. Number

NM

This Issue Prsht Rev. First Issue

Previous Run

: 2/22/2007

: NC

: 11 : 29922A Type

: SMALL /MED FAB

Written By

Checked & Approved By Comment

: Est Rev: A

New Issue

05-11-07

JLM

Part Number

Drawing Name

: D2280

: SPACER

Drawing Number

· D2280 REV D

Project Number **Drawing Revision** : N/A

Material

: NIM

: 2/6/2007 **Due Date**

Qty:

20 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6B0250X01000

6061-T6 Bar .25" x 1.0"

Comment: Qty.:

0.2975 f(s)/Unit Total:

Material: 6061-T6 (QQ-A-250/8) 0.25" Thick

(M6061T6B0.250x1.000)Identify as D2280

Batch: M/9055 SHEAR

SHEAR

5.9493 f(s)

Comment: SHEAR

Cut blank: (3.400") +/-0.020"

3.0

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



07.03.07

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2280 and Dwg D2280

2-Deburr Then Tumble

INSPECT PARTS AS THEY COME OFF MACHINE

4.0

5.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE QC8

SECOND CHECK

Comment: SECOND CHECK

0.3/0

Page 1

Form: mrocess

Dart Aerospace Ltd

W/O:		WORK ORDER (WORK ORDER CHANGES							
DATE	STEP PROCEDURE CHANGE		Ву	Date	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			,							
					i					
		-4								
Part No	•	PAR #: Fault Category:	NCR: Ye	No DO	QA: £	Date: <u>(</u>	7/03/08			

Part No: _	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: OffcR/of
			QA: N/C Closed:	Date:

NCR:			WORK OR	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
				•	}	•		

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:57:37 PM Kim Johnston User: **Process Sheet** Drawing Name: SPACER Customer: CU-DAR001 Dart Helicopters Services Job Number: 30813A Part Number: D2280 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 PACKAGING 1 PACKAGING RE Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

9.0 QC21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



1 87.03.08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvai QC Inspector				
						•					
Dort No.	_	DAD # . Fault Cataman.	NOD. Vaa			Data					

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
				<.				
							, I	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30813A
Description: Spacer	Part Number:	D2280
Inspection Dwg: D2280 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.150	+/-0.010	.153	/			
0.236	+/-0.010	-217	/			
3.270	+/-0.010	5.270				
3.020	+/-0.010	3.023				
2.135	+/-0.010	2.137				
1.135	+/-0.010	1.137				
0.250	+/-0.010	.253				
1.00	+/-0.030	1,004				
Ø0.128	+0.005/-0.000	8.129	/			
Ø0.213	+0.005/-0.000	9.214				
C'sink 0.250 x 90°	+/-0.010	250X 50				
		.,				
· · · · · · · · · · · · · · · · · · ·						
7			****			

Measured by:	50	Audited by:	cn	Prototype Approval:	N/A
Date:	01.03.04	Date:	07t03/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.10.12	New Issue P/O D2582	KJ/JLM LA	
В	06.03.08	Dwg Rev changed	KJ/JLM	
				//

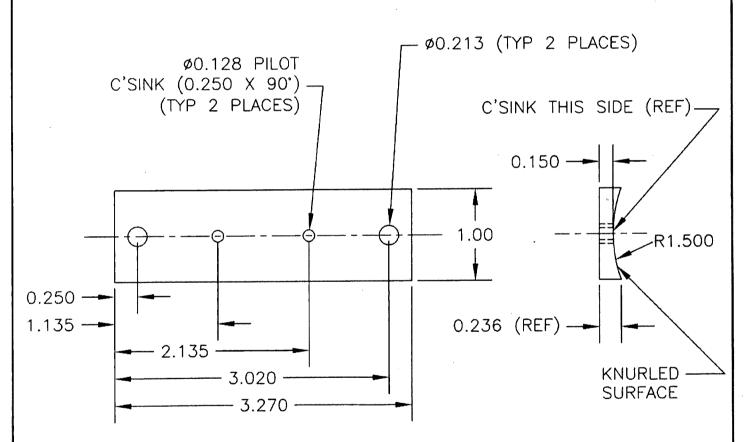
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CHECK	(ED W	APPROVED AN	DRAWING NO. RI	EV. D
	#	#	D2280 SHEET 1	OF 1
DATE			TITLE	SCALE
05.1	1.14		SPACER	1:1
Α		94.10.14	NEW ISSUE	
В		95.03.22	MATERIAL CHANGE, 0.15 WAS 0.20	

DELEASE N 65/11/28

	DAIL		THE
05.11.14		1.14	SPACER 1:1
	Α	94.10.14	NEW ISSUE
	В	95.03.22	MATERIAL CHANGE, 0.15 WAS 0.20
	С	98.09.29	0.188 DIA HOLE CHANGED TO 0.213
	D	05.11.14	ADD FINISHING NOTE



SHOP COPY

RETURN TO

ENGINEERING

D2280 SPACER

- MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8) BAR, 0.250 QNTROI SUBJECT TO AMENDME WITHOUT NOTICE (REF. DART SPEC M6061T6B1.000X00.250)
- WORK ORDER ACID ETCH AND ALODINE PER DART QSI 005 4.1 2) ALL DIMENSIONS ARE IN INCHES 3)
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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